

Date: Tuesday, 4/17/2007 11:13:23 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ADAPTER
Job Number : 31861	
Estimate Number : 12673	
P.O. Number : <i>NIA</i>	Part Number : D35731
This Issue : 4/17/2007 S.O. No. : <i>NIA</i>	Drawing Number : UNDER REVIEW <i>LS 07.05.07</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : <i>UR REV A</i>
Previous Run : 30627	Material : <i>NIA</i>
Written By : _____	Due Date : 5/12/2007 Qty: 40 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-01-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.3066 f(s)/Unit Total : 12.2640 f(s)

6061-T6 Bar .50" x 2.5"

Batch: *M103755 + 28 pieces*

M15919 + 5 pieces

ml 07/05/09

42

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank 3.500" long

ml 07/05/09

42

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA672 and Dwg D3573

1 ml 07/05/09

(42)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1 ml 07/05/09

(42)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07.05.10

(42)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 07/05/10

(42x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:13:23 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 31861

Part Number: D35731

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07-05-10 (42)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(42x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/05/11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 244

7/15/14 SP (42)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(42)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/14

Job Completion



W 07-05-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

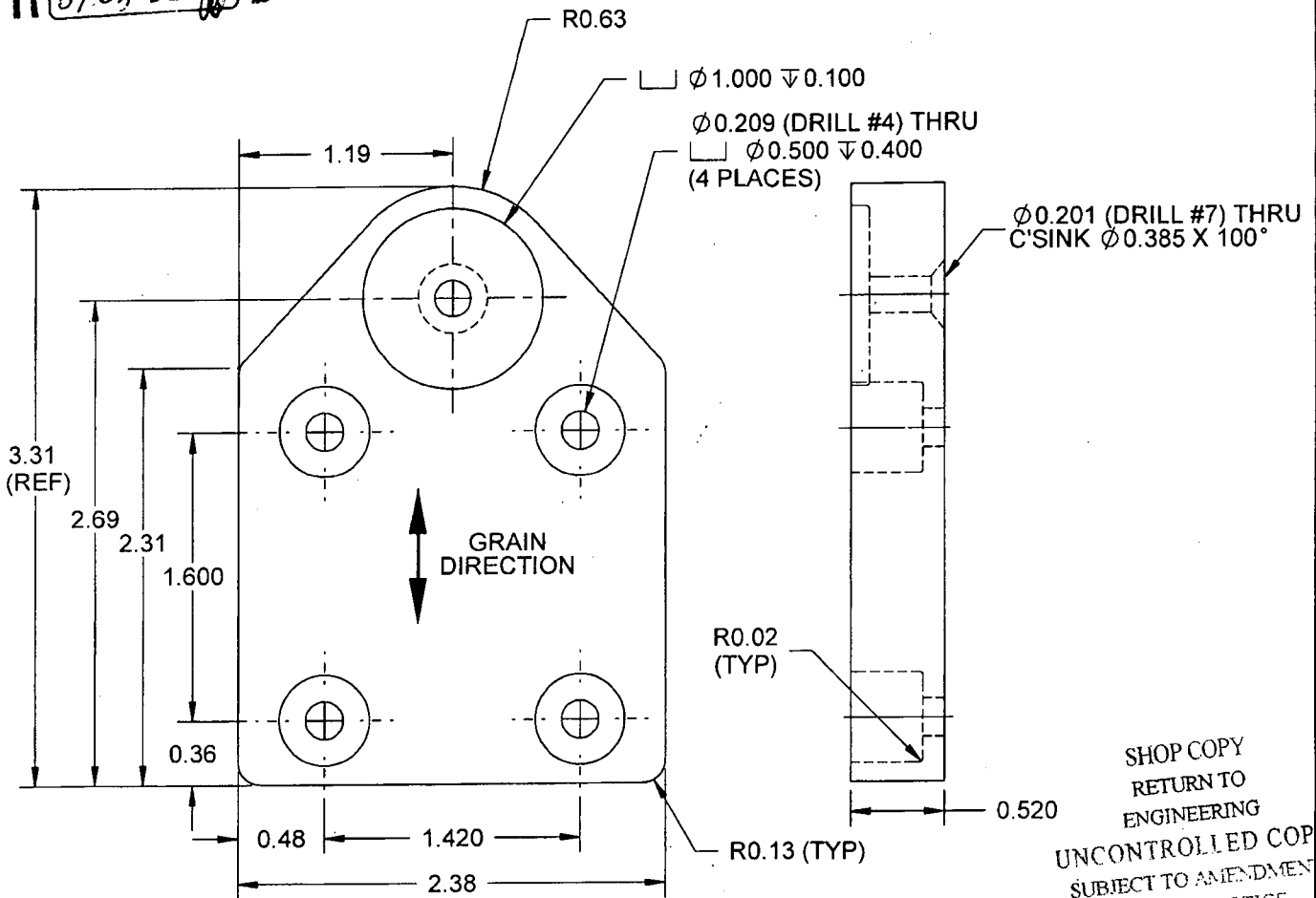
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

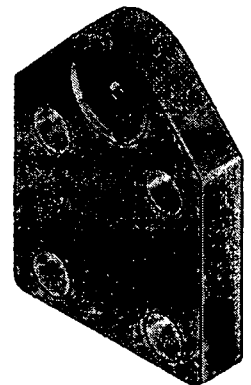
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER**

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **31861**

NOTES:

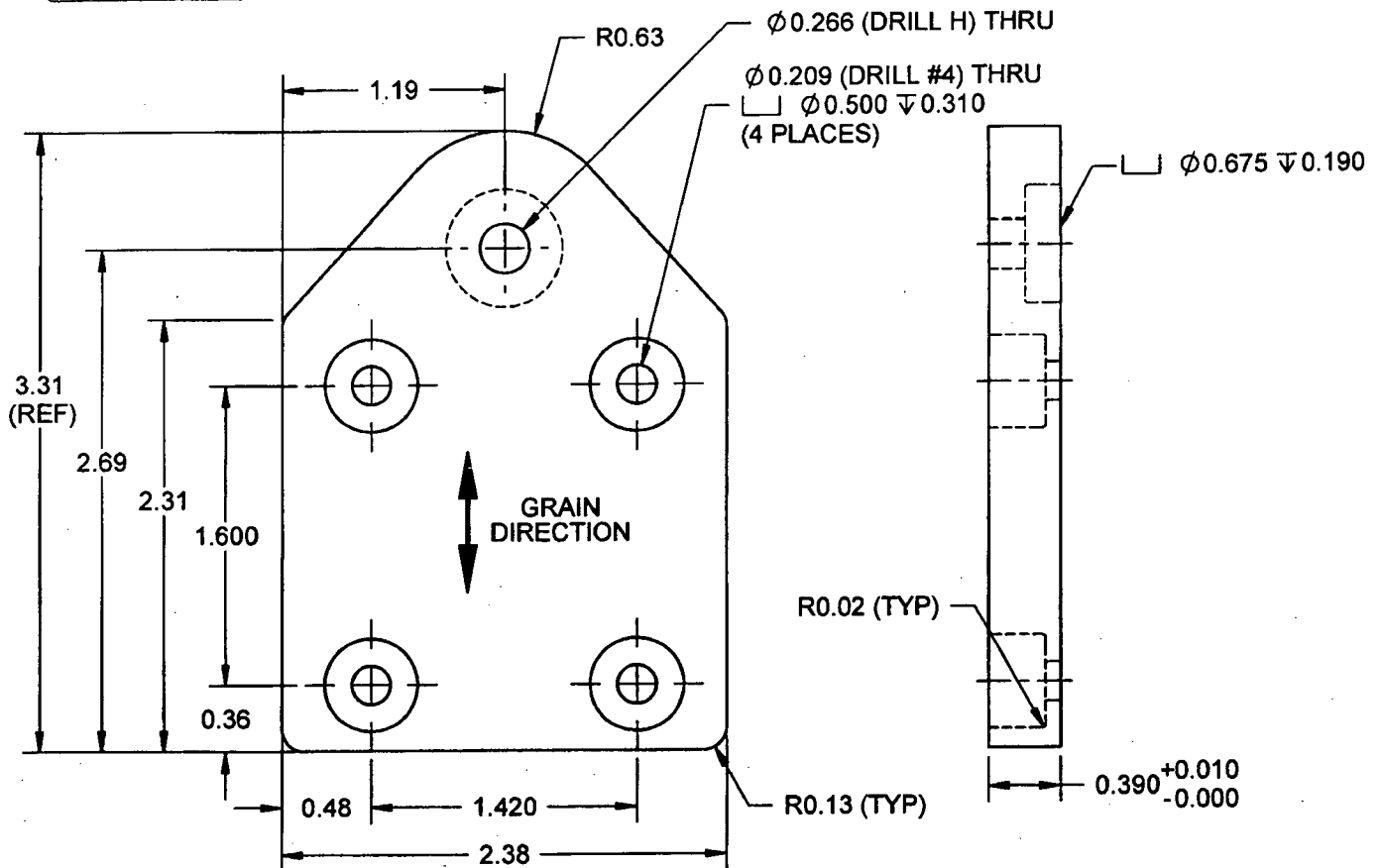
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 2 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02**D3573-3 ADAPTER**

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WORK ORDER
NO. 31861

NOTES:

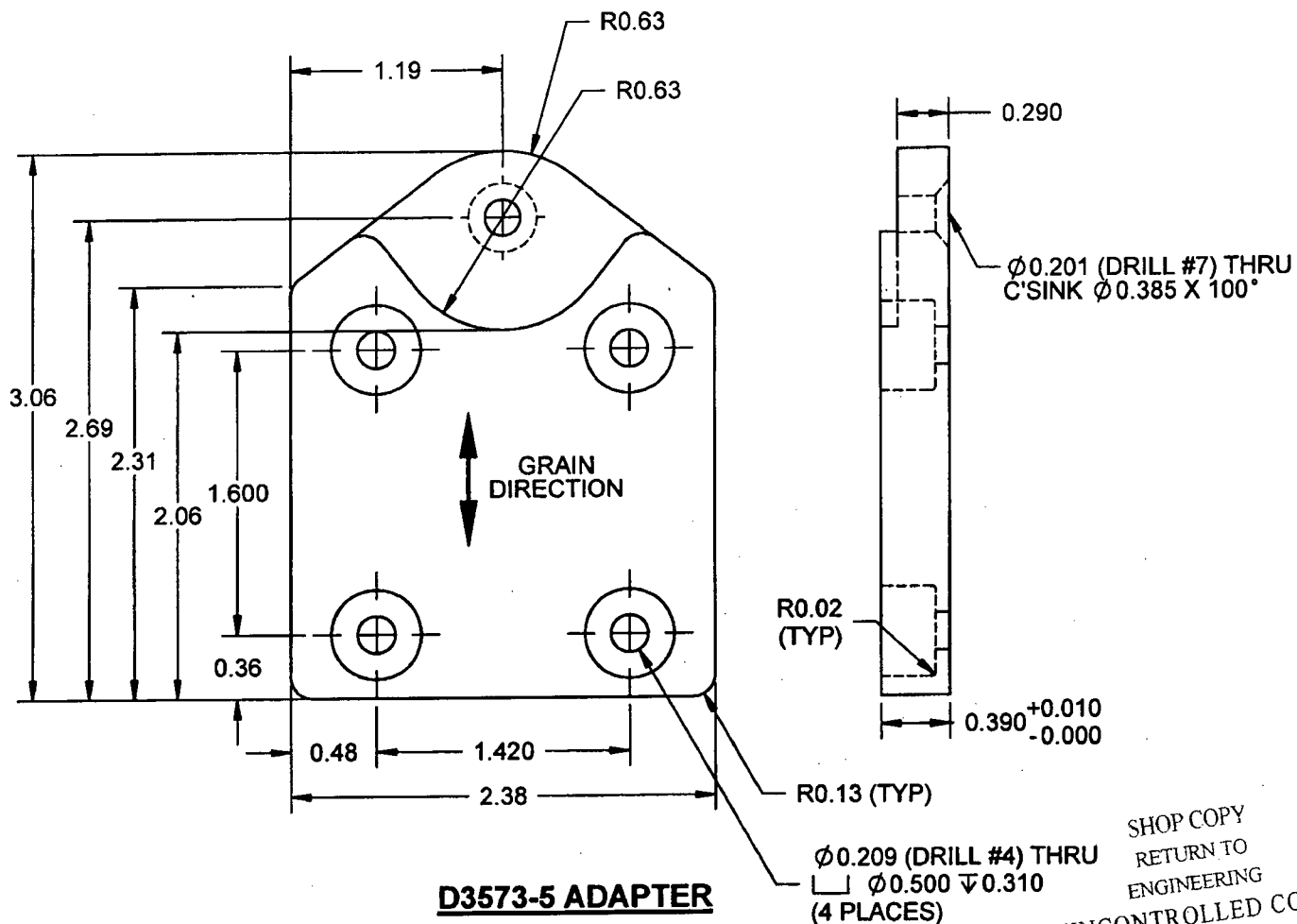
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

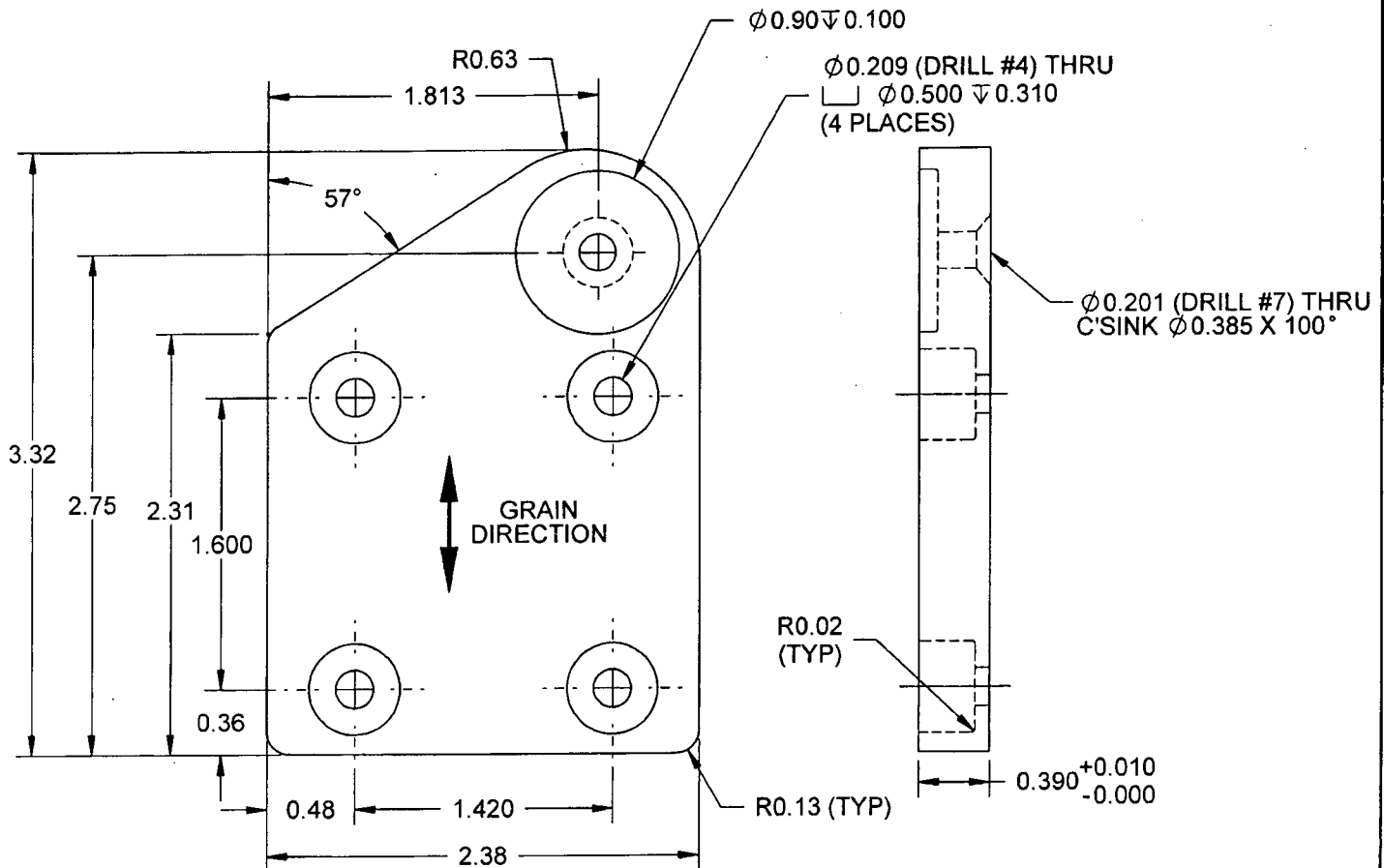
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NO. 31861

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

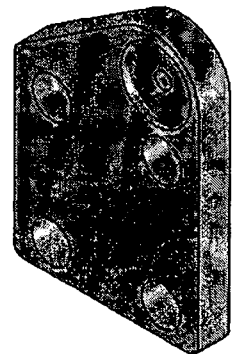
RELEASED
07.04.02

D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

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WORK ORDER
NO. 31861

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order: 31861
Description: ADAPTER	Part Number: D3573-1
Inspection Dwg: D3573 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R 0.13	± 0.030	R 0.125	—			
2.38	± 0.030	2.378	—			
1.420	± 0.005	1.421	—			
0.48	± 0.030	0.479	—			
0.36	± 0.030	0.359	—			
1.600	± 0.005	1.600	—			
2.31	± 0.030	2.310	—			
2.69	± 0.030	2.690	—			
3.31	± 0.030	3.313	—			
1.19	± 0.030	1.189	—			
R 0.63	± 0.030	R 0.630	—			
$\varnothing 1.000$	± 0.010 ± 0.001	$\varnothing 1.003$	—			
0.100	± 0.010	0.098	—			
$\varnothing 0.209$	± 0.005 ± 0.001	$\varnothing 0.211$	—			
$\varnothing 0.506$	± 0.006 ± 0.001	$\varnothing 0.502$	—			
0.400	± 0.010	0.398	—			
0.520	± 0.010	0.519	—			
$\varnothing 0.201$	± 0.005 ± 0.001	$\varnothing 0.203$	—			
$\varnothing 0.385 \times 100^\circ$	± 0.010	$\varnothing 0.385 \times 100^\circ$	—			

Measured by: Jnl	Audited by: JF	Prototype Approval: Jb
Date: 07/05/10	Date: 07.05.09	Date: 07.05.09

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	